

Work Order ID 53431

November 4, 2009 10:17:46 AM

Page 1

Item ID: D2435

Accept

Revision ID: E1

Item Name: Bearpaw, 206

Start Date: 11/09/09 Start Qty: 8.00

Required Date: 11/13/09 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B 9-11-16

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.A 09/11/22

S.A 09/11/22

12

(4) (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53431



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Item ID: D2435

Accept



Setup Start



Revision ID: E1

Stop



Item Name: Bearpaw, 206

Start Date: 11/09/09 Start Qty: 8.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: *PPD*

0.00



Packaging

Memo

52232 87

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/11/24

09/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53431



Parent Item: D2435RevE1



Parent Item Name: Bearpaw, 206



Start Date: 11/09/09

Required Date: 11/13/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	219.8629	25.6000	32.		
UHMW 1" Black												89-11-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

177.7752

112186

126.5752

112514

51.2

Main Warehouse

ST

42.0877

111354

42.0877

113166



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53431
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.065 x 45°	✓		
B	5.500	+/-0.030	5.505	✓		
C	0.200	+/-0.030	0.196	✓		
D	R0.250	+/-0.030	R0.250	✓		
E	0.250	+/-0.010	0.250	✓		
F	0.625	+/-0.030	0.629	✓		
G	0.25 x 45°	+/-0.030	0.257 x 45°	✓		
H	0.375	+/-0.010	0.380	✓		
I	19.000	+/-0.030	19.000	✓		
J	0.950	+0.030/-0.010	0.962	✓		
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		
L	Ø0.930	+/-0.030	Ø0.925	✓		
M	0.30	+0.030/-0.000	0.315	✓		
N	0.375	+/-0.030	0.382	✓		
O	7.375	+/-0.030	7.375	✓		
P	4.250	+/-0.010	4.252	✓		
Q	2.000	+/-0.030	2.006	✓		
R	9.000	+/-0.010	8.998	✓		
S	15.750	+/-0.030	15.750	✓		

Measured by: G.A.	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/11/22	Date: 09/11/23	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	[Signature]



DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PW		APPROVED JS		DRAWING NO. D2435 REV. E SHEET 1 OF 2	
DATE 98.05.19		TITLE BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

EFFECTIVE DEOS

9143

DEPOS

RELEASED
43.06 17 KE

49 06 17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

— 7.500

△ EN

Ø 0.260 (TYP) Ø 0.93 C-BORE

~~Ø 0.75 C-BORE 0.30 DEEP FROM BOTTOM~~

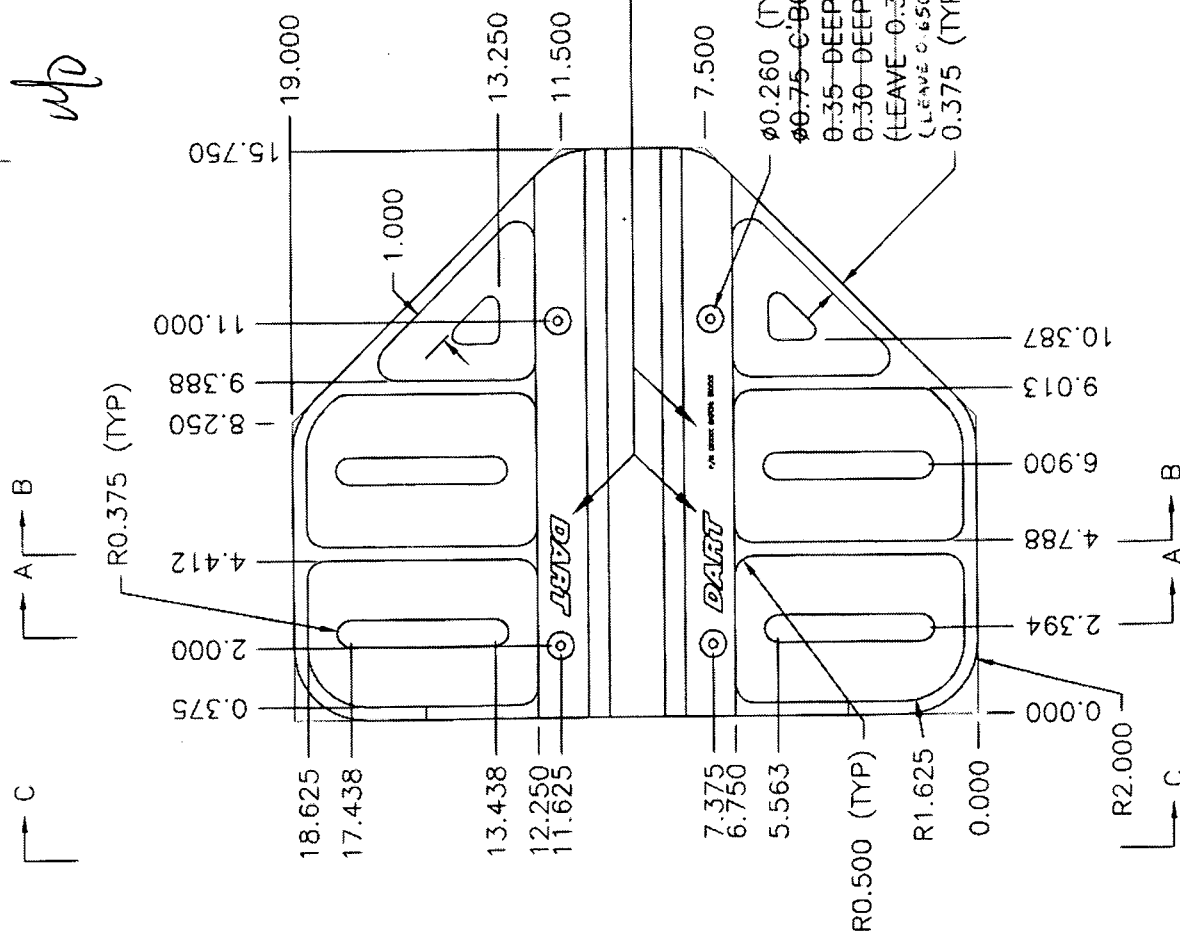
~~0.35 DEEP FROM TOP (MIN.)~~

~~0.30 DEEP FROM BOTTOM~~

~~(LEAVE 0.300 MIN.)~~

~~(LEAVE 0.650 MIN.)~~

0.375 (TYP) △ EN



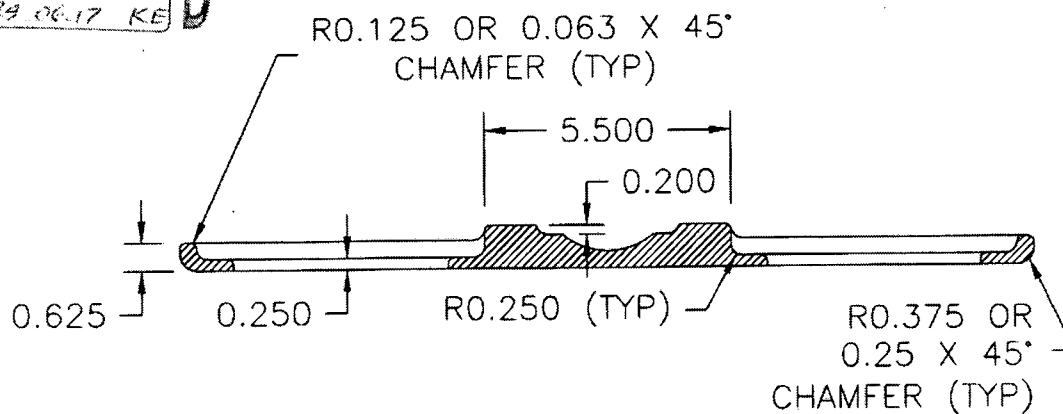
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



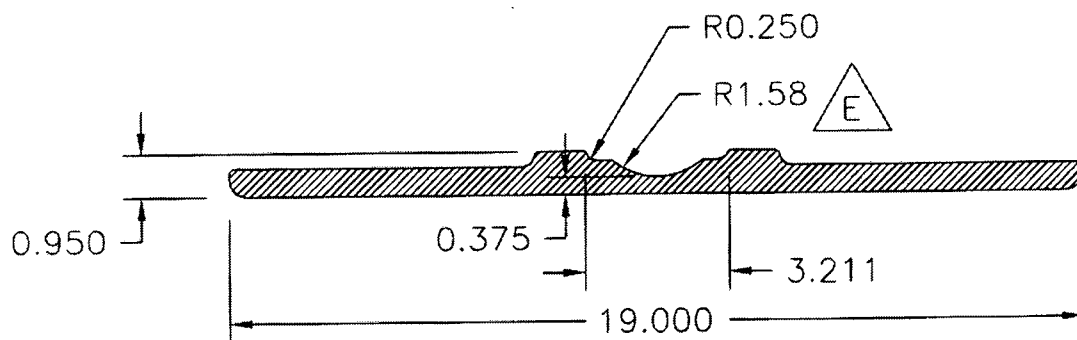
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED BIB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98 06 17 KE

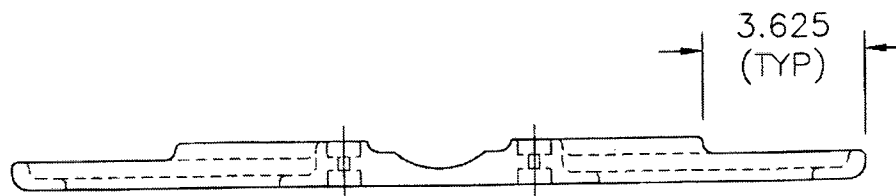
wp 5343/



SECTION A-A



SECTION B-B



SECTION C-C